

Date: Wednesday, 9/19/2007 2:59:09 PM
 User: Chantal Lavoie

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 3" OUTER TUBE
Job Number	: 34715		
Estimate Number	: 10053		
P.O. Number	: N/A	Part Number	: D26001160
This Issue	: 9/19/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2600 REV D1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30249	Drawing Revision	: D1
		Material	: N/A
Written By	: <u>W</u>	Due Date	: 9/28/2007
Checked & Approved By	: <u>W</u>	Qty:	98 110 Um: Each
Comment	: Est. D: 02.09.05 Added DSK 066 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

4623

C207/09/19

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 160" long
- g) Bon L Canada Inc. tool # 897121
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

(110)

2.0

D26001160P

Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 110.0000 Each(s)

Extrusion Round 3" 206

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

Cp 207/10/01 (98)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/19/2007 2:59:10 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 34715

Part Number: D26001160

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2600

Check Pull test per Dwg D2600 for compliance page attached

Check hardness with Webster tester

Sn 0710603 counter (98)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/9 sg (98)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(98) 071011

Job Completion



W 07-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>FCP</i>	

RELEASED
98 08 25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

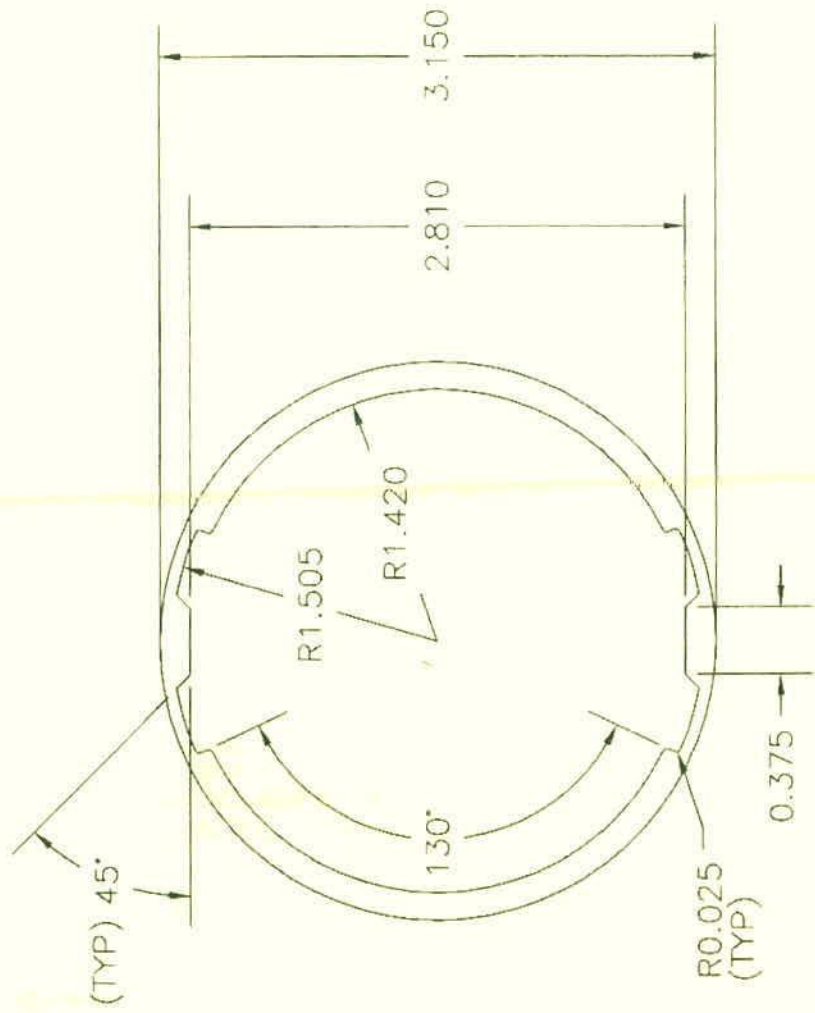
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

0207/09/19
W10: 31715



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DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 877122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3 - XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120 LONG)



7/09/19
w/o: 347/5

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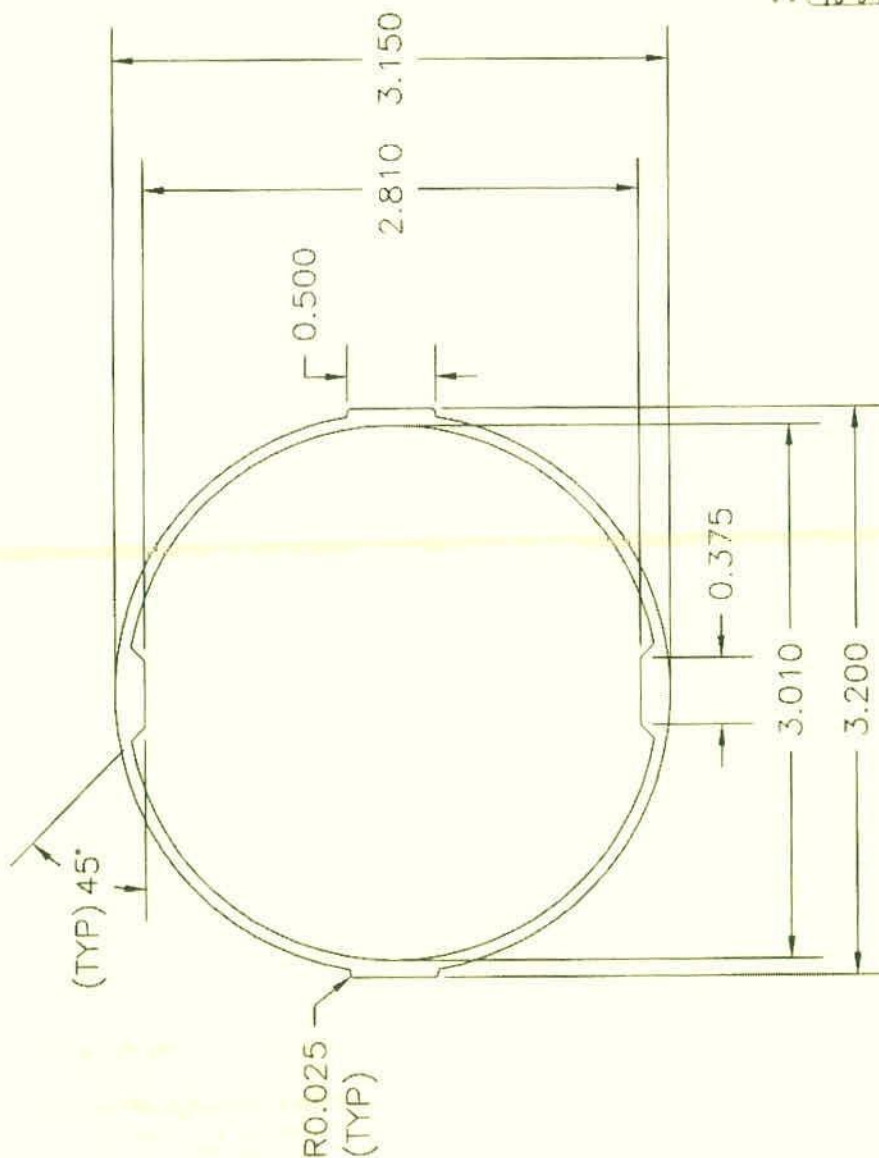
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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR RON L DIE # 897121 (REFERRED CHOICE)

PART NUMBER IS D2600-1-XX WHERE XX IS CUT LENGTH IN INCHES (EG D2600-1-100 IS 100 LONG)



C207109119

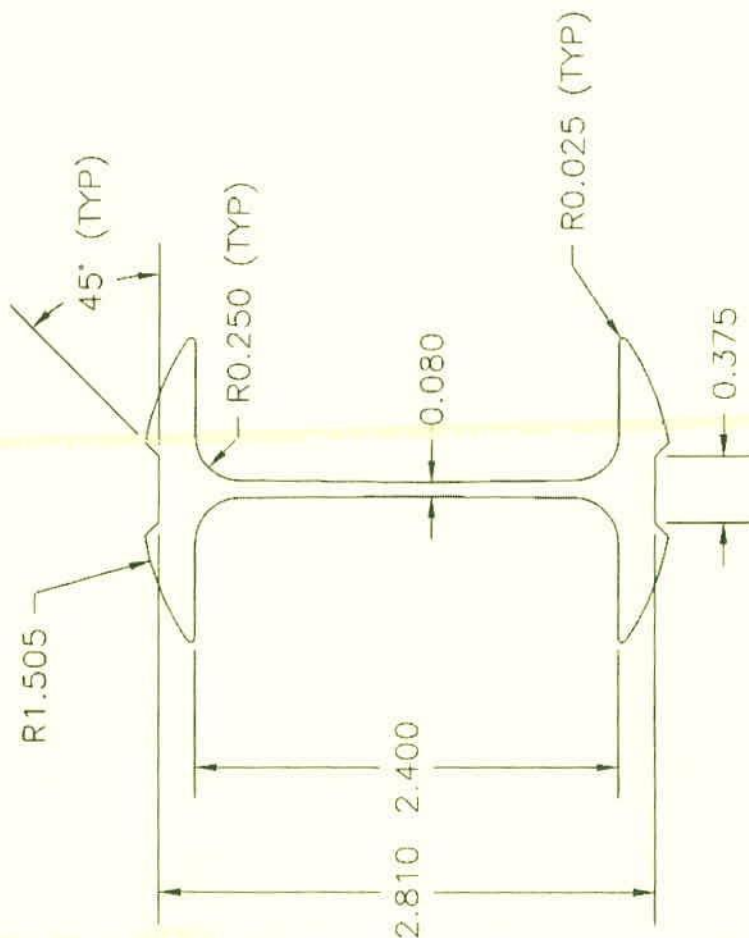
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CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. 0 SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98 8 25 DS



D2600-7

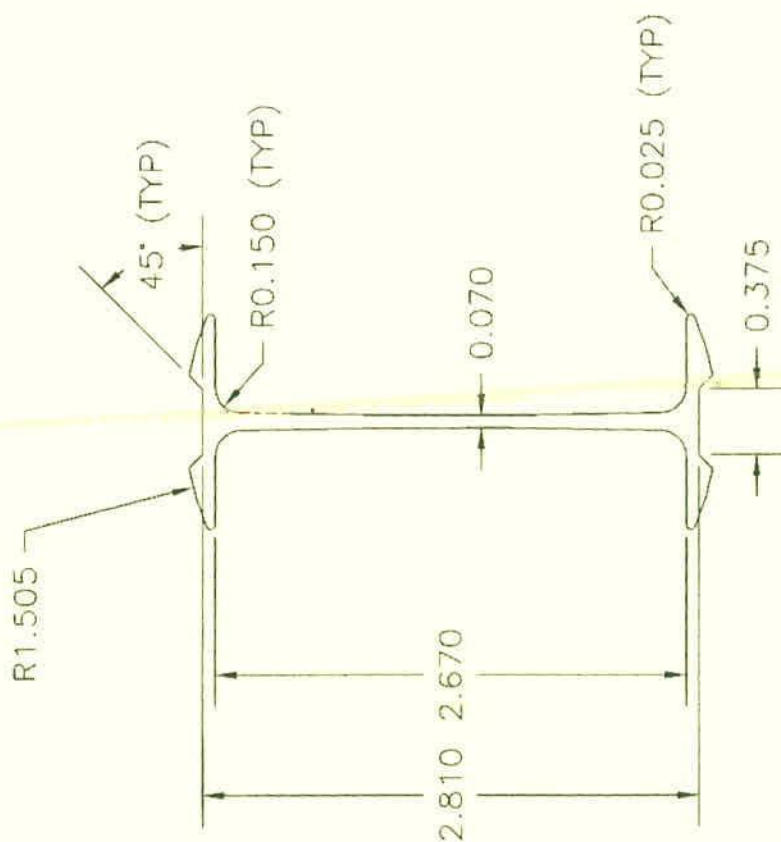
MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-7-125 IS 125" LONG)





DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98 8 25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-S-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG- D2600-S-108 IS 108" LONG)



C207109119

W/O: 347/5

CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Part Date	Part No	Sales Order	Page
09/28/07	166771	87236	1
Cust PO	B/L No	Lot	Date
4623	00359007	87236010	9/28/07

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897121-1	160" Mill 6061 T6	D2600-1-160
Gross Weight	623 KGS		
Net Qty	603 KG	98 PC	398 M
Specification	AMS-QQ-A-200/8 & ASTM B221-00		
	Die Desc		

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	316.6 / 45.9	289.7 / 42.0	10.2	.0	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.05	.89	.05	.007	.07	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

Handwritten signature: 12/10/03

